

Date: Monday, 6/5/2006 11:01:49 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 27420
 Estimate Number : 11019,
 P.O. Number : *N/A* Part Number : D27313
 This Issue : 6/5/2006 S.O. No. : *N/A* Drawing Number : D2731 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : B
 Previous Run : *N/A* Material : *N/A*
 Written By : *See comment below* Due Date : 7/10/2006 Qty: 50 Um: Each
 Checked & Approved By : *JF 06-06-05*
 Comment : Est:D 00.05.19 Added inspect level 8, removed P/O for powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 3.5858 f(s) *23779 / 20 PCS*

Lug Extrusion D2423

Batch: *1323779 / 33 PCS*

J.F. 06/06/17

(53)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 0.82" Long

J.F. 06/06/17

(53)

3.0 HAAS HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2731-3

Check for crack while loading into the machine

Tumble Deburr any rough edges after tumbling

P/O 1521

CL06120106 (53)

4.0 *QC2* INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit

Damage / 06/7/21

(51)

5.0 *QC5* SECOND CHECK



Comment: SECOND CHECK

Inspect level 21

060724 (51)

5-1 Tumble parts N/A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/08/01

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:49 AM
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Drawing Name: LUG

Job Number: 27420

Part Number: D27313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/25

(51)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-07-25

(51)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 06/07/28 (51)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY48

AS 06/07/28 (51)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

9/26/08/01 (51)

Job Completion



C20713112006

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

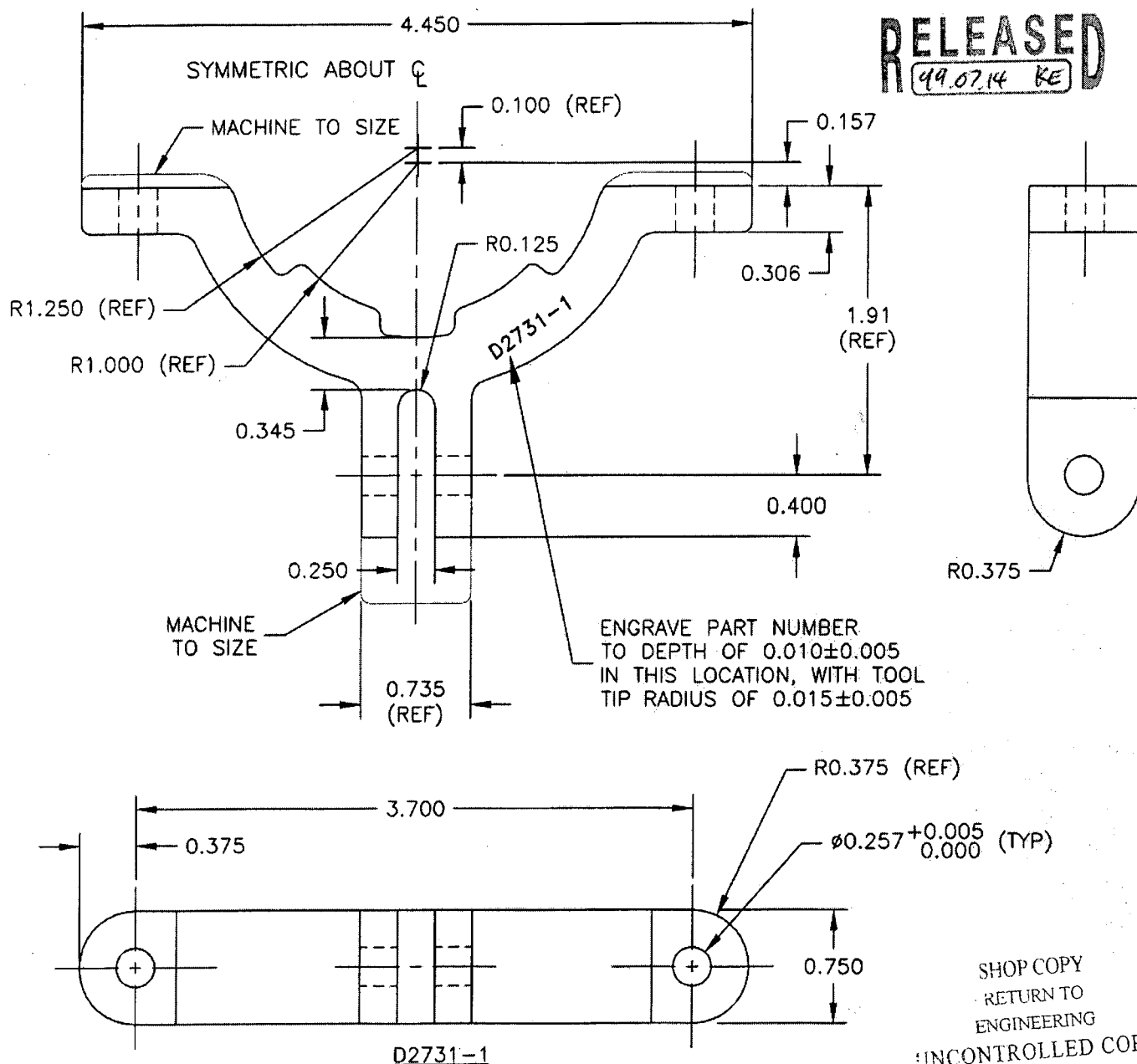
NOTE: Date & initial all entries

NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



RELEASED
99.07.14 KE

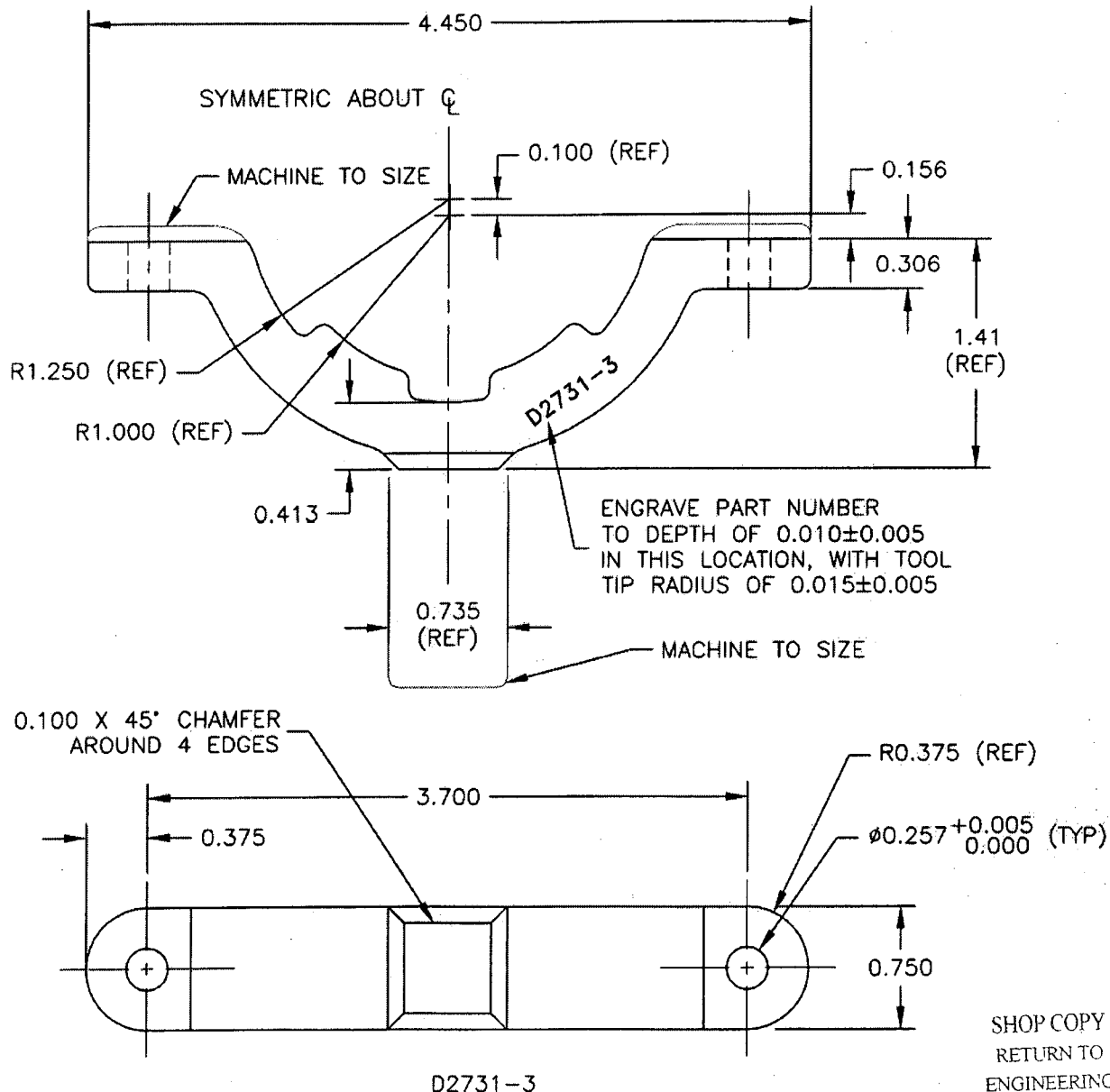
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 27420



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DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
19.07.14 *KE*



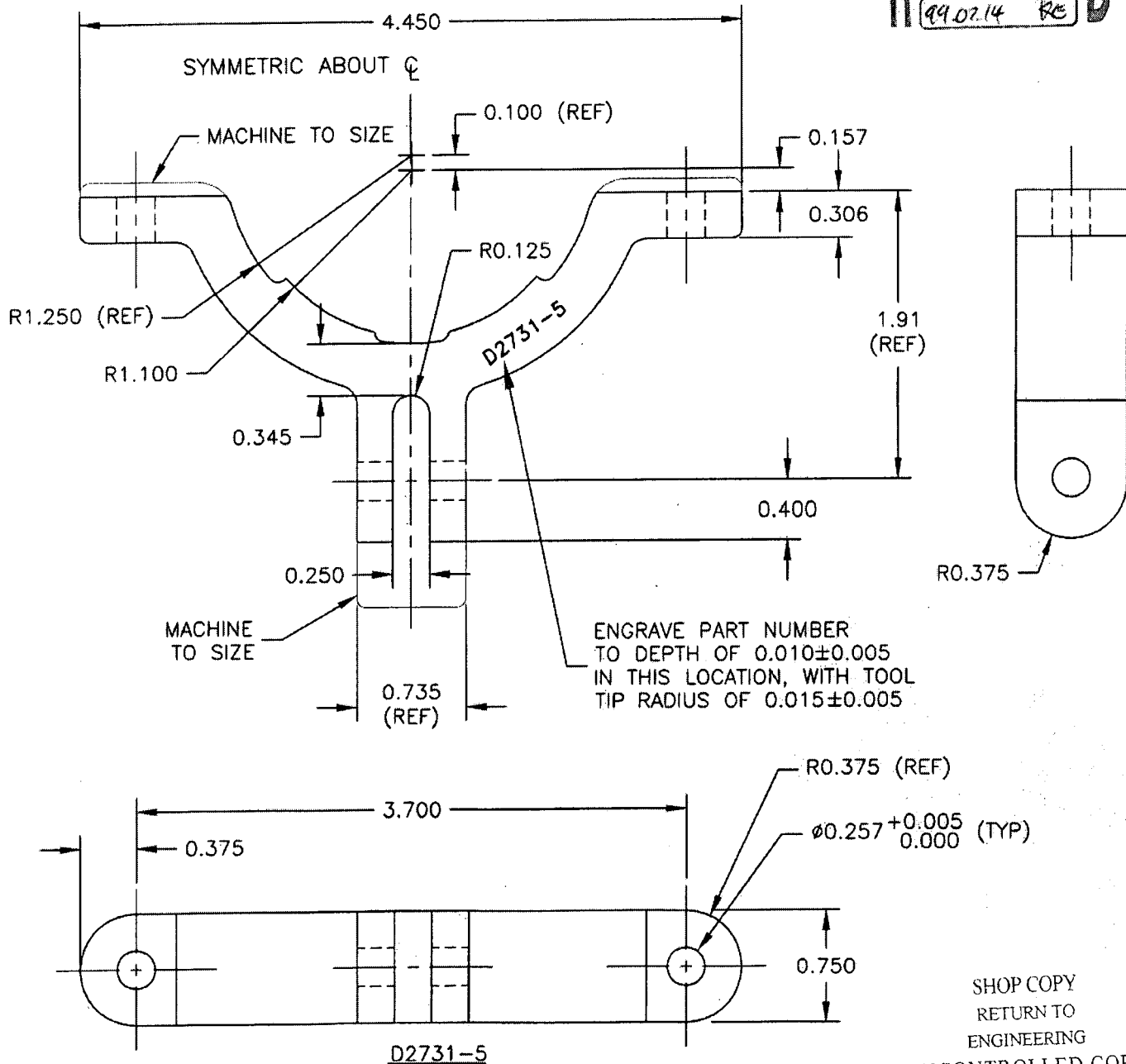
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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *RE*

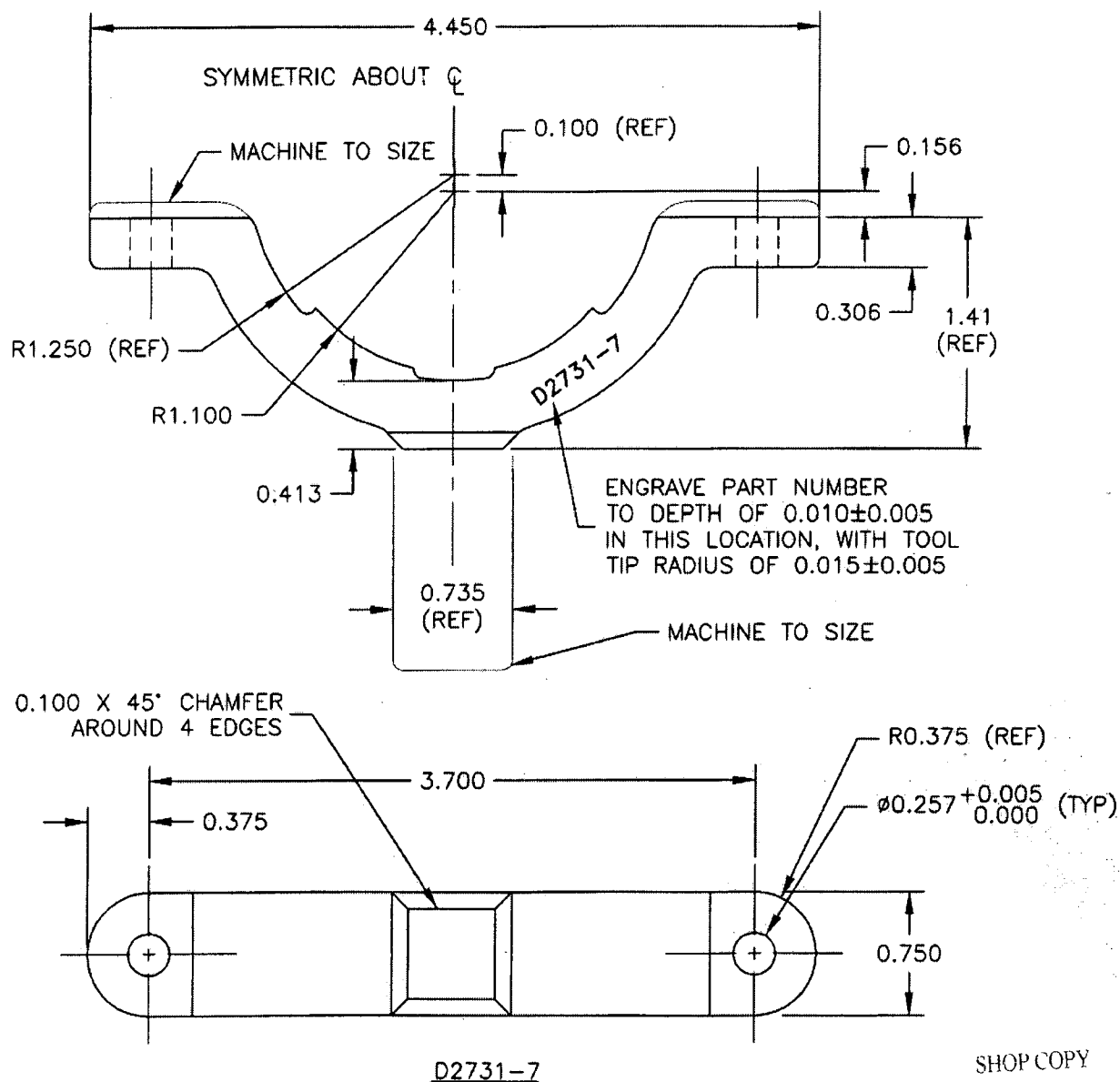


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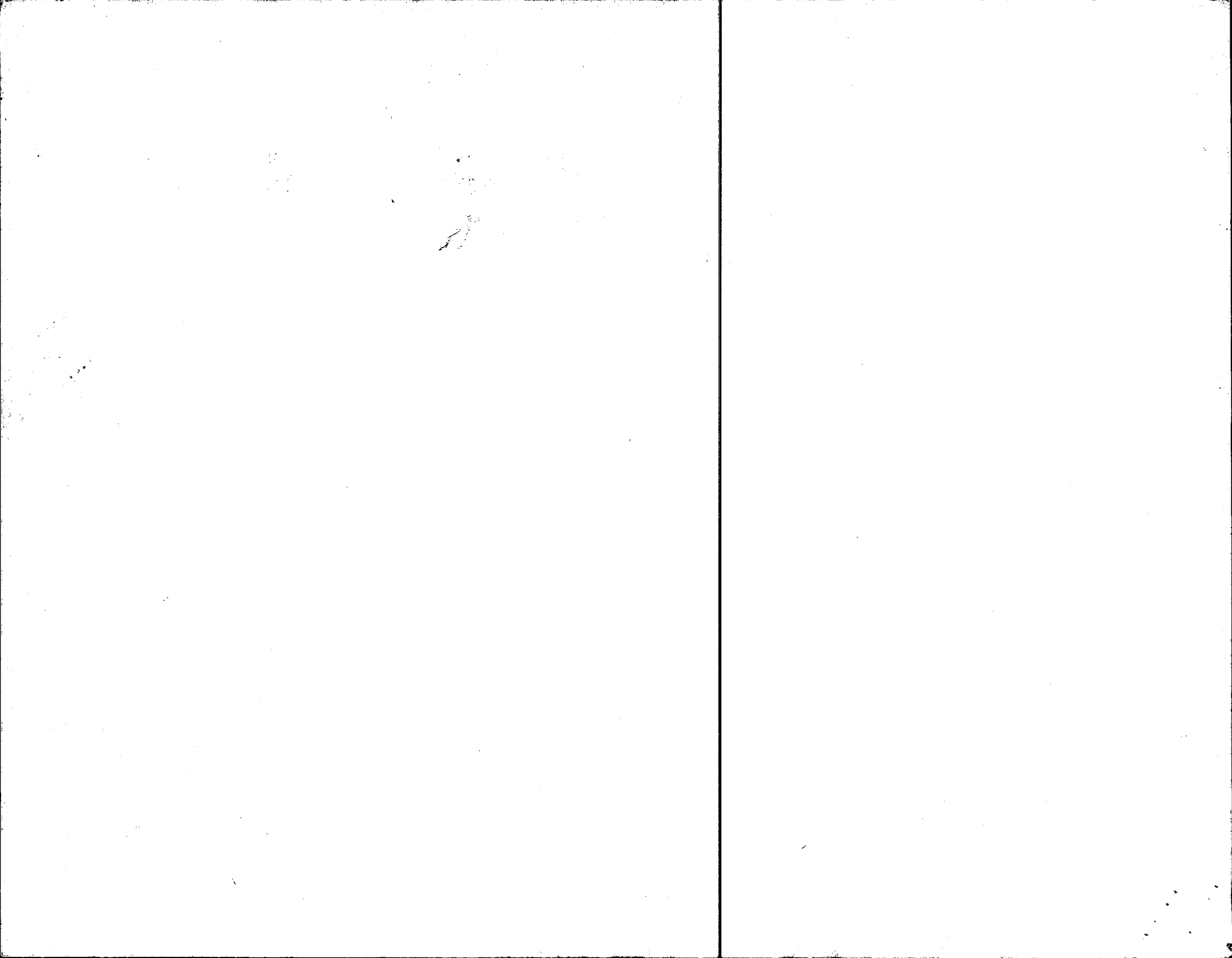
DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

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NO. 27420



Delivery Slip: **15443**
Date: **21 07-Jul-2006**
Page No.: **1**

Sold To: Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7

Ship To: Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7

P.O. Number 1521

Description	Quantity			Unit
	ordered	shipped	B/O	
D2230-3 Mounting Lug				Each
D2731-1 Mounting Lug				Each
D2731-3 Mounting Lug		51		Each
Received by _____				
Thank you for your order.				



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

51

PART NUMBER

D 2731-3

PART NAME

Mounting Lug

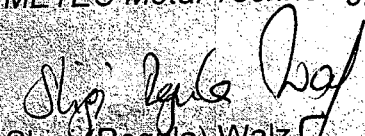
P.O. NUMBER

1521

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shig (Regula) Walz

Vankleek Hill, July 21, 2006

